

# Work Order ID 110144

December-17-13 9:16:05 AM

**\*110144\***

Page 1

Item ID: D3826-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Rib / Gusset Assembly

Start Date: 12/20/13 Start Qty: 16.00

~~\*16\*~~ **4x**  
~~\*16\*~~

Cust Item ID:

Required Date: 12/20/13 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 13-12-18

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3826	Rev B

100 Large Fab 0.00

**\*100\***

Large Fab

Memo

0.00

Large Fab

1- assemble D2325 support gusset together

2- locate D2325 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: B123823

4x CC 14-3-5

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Memo

0.00

Quality Control

DAS 43 14-03-05

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS 43 14-03-05

4.3

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**\*110144\***

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Setup Start

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Revision ID:

Stop

**\*NS2\***

Item Name: Rib / Gusset Assembly

Start Date: 12/20/13 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 12/20/13 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: *W/A*

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

*4x CC 14-3-5*

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*R14-03-6**① 14-03-06*

# Picklist Print

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Page 1

Work Order ID: 110144

Parent Item: D3826-041

Start Date: 12/20/13

Required Date: 12/20/13

Parent Item Name: Rib / Gusset Assembly

Start Qty: 16.00

Required Qty: 16.00

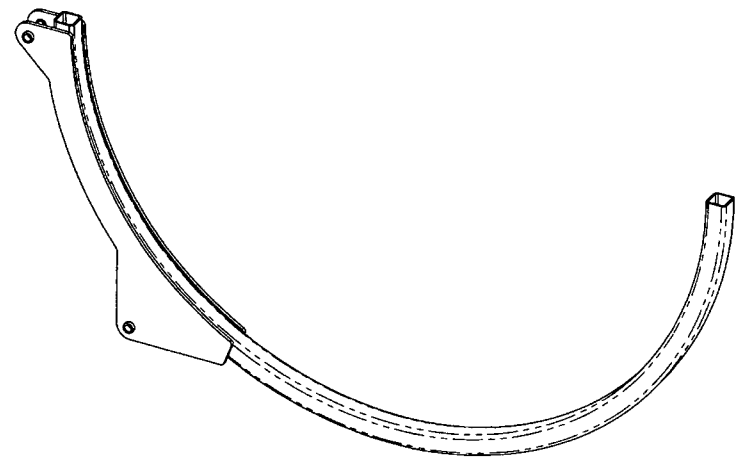
Comments: IPP Rev:A 08-12-01 new.issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2235-1 Basket Rib		Manufactured	No			100	Each	3.0000	1	16			
<u>Location</u>													
						<u>Loc Qty</u>	<u>Loc Code</u>						
						3	B104946	→ (4)					
						1							
						2							
D3929-041 Gusset Assembly		Manufactured	No			100	Each	23.0000	1	16			
<u>Location</u>													
						<u>Loc Qty</u>	<u>Loc Code</u>						
						23							
						13							
						10		(4)					
D3929-042 Gusset Assembly		Manufactured	No			100	Each	27.0000	1	16			
<u>Location</u>													
						<u>Loc Qty</u>	<u>Loc Code</u>						
						27							
						11		(4)					
						8							
						8							

8 7 6 5 4 3 2 1

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△B



**D3826-041 RIB/GUSSET ASSY**

110144 MCTJ  
13-12-18

**RELEASED**  
8/10/12 MCTJ

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 3.32 lbs

△B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.		MB	09.04.16
A	NEW ISSUE		MB	08.09.23
REV.	DESCRIPTION		BY	DATE
DESIGN	16		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	5		DRAWING NO. REV. B	
CHECKED	10		D3826 SHEET 1 OF 2	
MFG. APPR.	14		TITLE SCALE	
APPROVED	14		RIB/GUSSET ASSY NTS	
DE APPR.	14		DATE 09.04.16	
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8 7 6 5 4 3 2 1

△ B D3929-042  
GUSSET ASSEMBLY

△ B D3929-041  
GUSSET ASSEMBLY

TYP

0.250

D2235-1  
RIB

**D3826-041 RIB/GUSSET ASSY**

**RELEASED**  
9/24/12

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

